

Date: Wednesday, 1/18/2006 4:05:21 PM
 User: Kim Johnston

Process Sheet

| | |
|--|--|
| Customer : CU-DAR001 Dart Helicopters Services | Drawing Name : BRACKET ASSEMBLY |
| Job Number : 25557B | |
| Estimate Number : 10290 | |
| P.O. Number : N/A | Part Number : D3121144 |
| This Issue : 1/18/2006 S.O. No. : N/A | Drawing Number : D3121 REV C2 |
| Prsht Rev. : NC | Project Number : N/A |
| First Issue : N/A Type : MACHINED PARTS | Drawing Revision : C2 |
| Previous Run : 25442B | Material : N/A |
| Written By : <u>SEE COMMENT BELOW</u> | Due Date : 2/15/2006 |
| Checked & Approved By : <u> </u> | Qty: 4 Um: Each |
| Comment : Est Rev:Pick:A 04.02.18 New issue KJ/DS | |

Additional Product

Job Number:



| | | |
|----------------|------------------------------|----------------------|
| Seq. #: | Machine Or Operation: | Description : |
|----------------|------------------------------|----------------------|

| | | |
|-----|-----------------|-------------|
| 1.0 | M174B1000X02000 | 17-4 SS Bar |
|-----|-----------------|-------------|



Comment: Qty.: 0.3864 f(s)/Unit Total : 1.5456 f(s)
 Material: 17-4 SS Bar per AMS 5604/5643
 (M17-4-B1.000x02.000)
 Identify for D3121-114
 Batch: M17712

J.L / S.D

06.02.17

4

| | | |
|-----|----------|----------|
| 2.0 | BAND SAW | BAND SAW |
|-----|----------|----------|



Comment: BAND SAW
 Cut blanks: (1.000" x 2.000") 4.425" long

J.L / S.D

06.02.17

4

| | | |
|-----|-------|--------------------------------|
| 3.0 | HAAS1 | HAAS CNC VERTICAL MACHINING #1 |
|-----|-------|--------------------------------|



Comment: HAAS CNC VERTICAL MACHINING #1

1-Machine D3121-114 as per Folio FA330 and Dwg D3121 Identify as D3121-114

2-Deburr

3-Scribe batch number

J.L 06.02.18

4

| | | |
|-----|-----|--|
| 4.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

J.L 06.02.18

4

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Wednesday, 1/18/2006 4:05:21 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 25557B

Part Number: D3121144

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

MS 06/02/18 4

6.0

D312121

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-21

Bolt B25456

J.L 06.02.18

7.0

D3121241

Bearing Assembly



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 D3121-241 Bearing Ass

B25225

J.L 06.02.18

8.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble D3121-143 as per Dwg D3121.

J.L 06.02.18 4

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

MS 06/02/18 4

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST 408

C 206102/20 (4)

11.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

5.0 06/02/21 (4)

06/02/21 (4)

Job Completion



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PD Date: 06/07/21
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

| | | | |
|------------------------------|----------------|---------------------|-----------|
| DART AEROSPACE LTD | | Work Order: | 25557B |
| Description: Bracket | | Part Number: | D3121-114 |
| Inspection Dwg: D3121 | Rev: B1 | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| 1.800 | +/-0.010 | 1.801 | ✓ | | | |
| R0.25 | +/-0.030 | .250 | ✓ | | | |
| 0.30 | +/-0.030 | .300 | ✓ | | | |
| 0.015 | +/-0.010 | .010 | ✓ | | | |
| 0.392 | +0.002/-0.000 | .392 | ✓ | | | |
| 2.24 | +/-0.030 | 2.230 | ✓ | | | |
| 3.67 | +/-0.030 | | | | | |
| 3.41 | +/-0.030 | 3.416 | ✓ | | | |
| 0.130 | +/-0.010 | .132 | ✓ | | | |
| 2.540 | +/-0.010 | 2.541 | ✓ | | | |
| 2.220 | +/-0.010 | 2.218 | ✓ | | | |
| 1.590 | +/-0.010 | 1.590 | ✓ | | | |
| 0.160 | +/-0.010 | .161 | ✓ | | | |
| 3.80 | +/-0.030 | 3.795 | ✓ | | | |
| 0.400 | +/-0.010 | .401 | ✓ | | | |
| 1.220 | +/-0.010 | 1.228 | ✓ | | | |
| 1.600 | +/-0.010 | 1.601 | ✓ | | | |
| 0.400 | +/-0.010 | .399 | ✓ | | | |
| 0.201 | +/-0.010 | .202 | ✓ | | | |
| 0.381 | +/-0.010 | .389 | ✓ | | | |
| 0.580 | +/-0.010 | .587 | ✓ | | | |
| 0.032 | +/-0.010 | .029 | ✓ | | | |
| | | | | | | |
| | | | | | | |

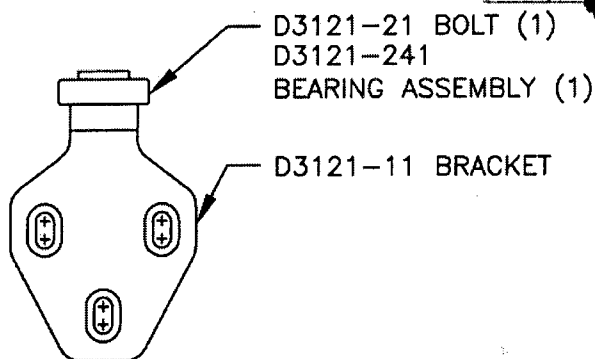
| | | | |
|-------------------------|-----------------------|----------------------------|-----|
| Measured by: J.L | Audited by: E | Prototype Approval: | N/A |
| Date: 06.02.18 | Date: 06/02/18 | Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|-----------|------------|----------|
| A | 03.12.08 | New Issue | KJ/RF | |

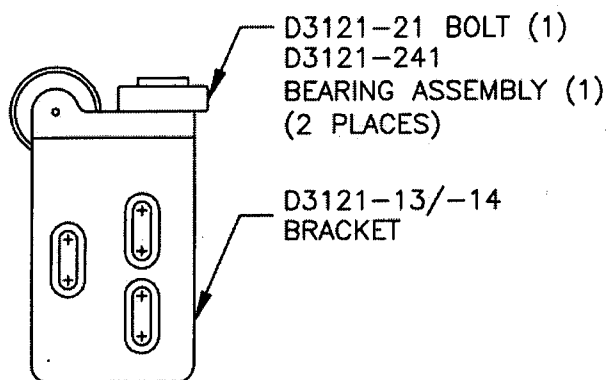


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| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. C SHEET 1 OF 10 |
| DATE 04.02.17 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |
| A | 02.04.15 | NEW ISSUE | |
| B | 03.01.16 | ADD RIDGES; ADD MAT'L PROP; FIX P/N ADD -141/-143/-144/-145/-146 | |
| C | 04.02.17 | ADD CLEARANCE; USE -241 BEARING | |
| C1 | 04.03.26 | 3.97 WAS 4.00; 6.11 WAS 6.14 | |
| C2 | 04.04.26 | 0.230 WAS 0.238 | |

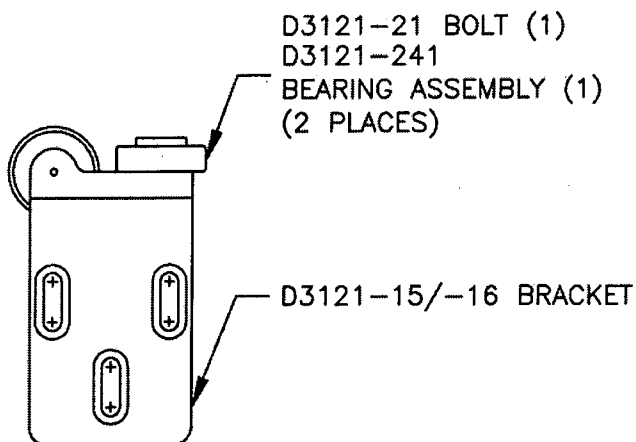
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04-03-01



D3121-041 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-33)



D3121-043 (SHOWN) / D3121-044 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-37/-38)



D3121-045 (SHOWN) / D3121-046 (OPPOSITE) BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-35/-36)

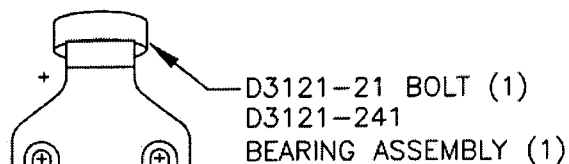
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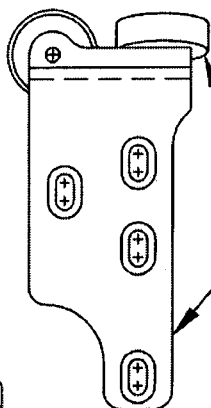
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| DATE 04.02.17 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |



D3121-21 BOLT (1)
D3121-241
BEARING ASSEMBLY (1)

D3121-111 BRACKET

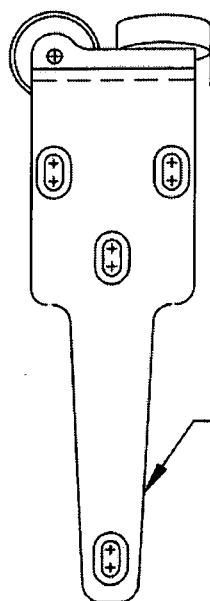
D3121-141 BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23001-01)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-113/-114 BRACKET

D3121-143 (SHOWN) / D3121-144 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-03/-04)



D3121-21 BOLT (1)
D3121-241 BEARING ASSEMBLY (1)
(2 PLACES)

D3121-115/-116
BRACKET

D3121-145 (SHOWN) / D3121-146 (OPPOSITE)
BRACKET ASSEMBLY
(REPLACES PREMIER P/N B30-23000-05/-06)

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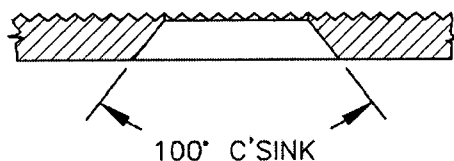
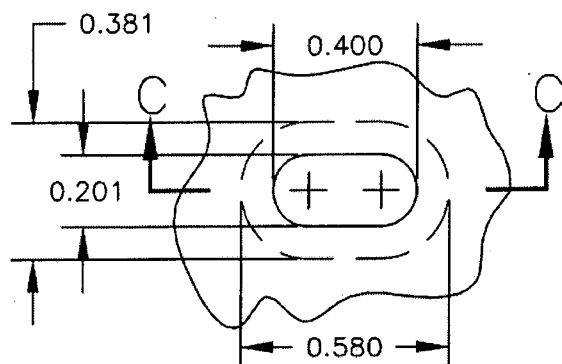
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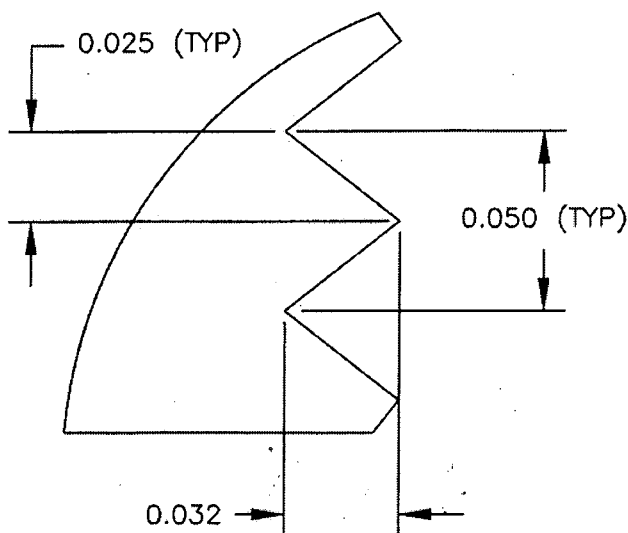
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DETAIL A:
SLOT DETAIL
SCALE 2:1
VIEW ROTATED



SECTION
C-C

DETAIL B:
RIDGE DETAIL
PARTIAL SECTION
SCALE 1:20



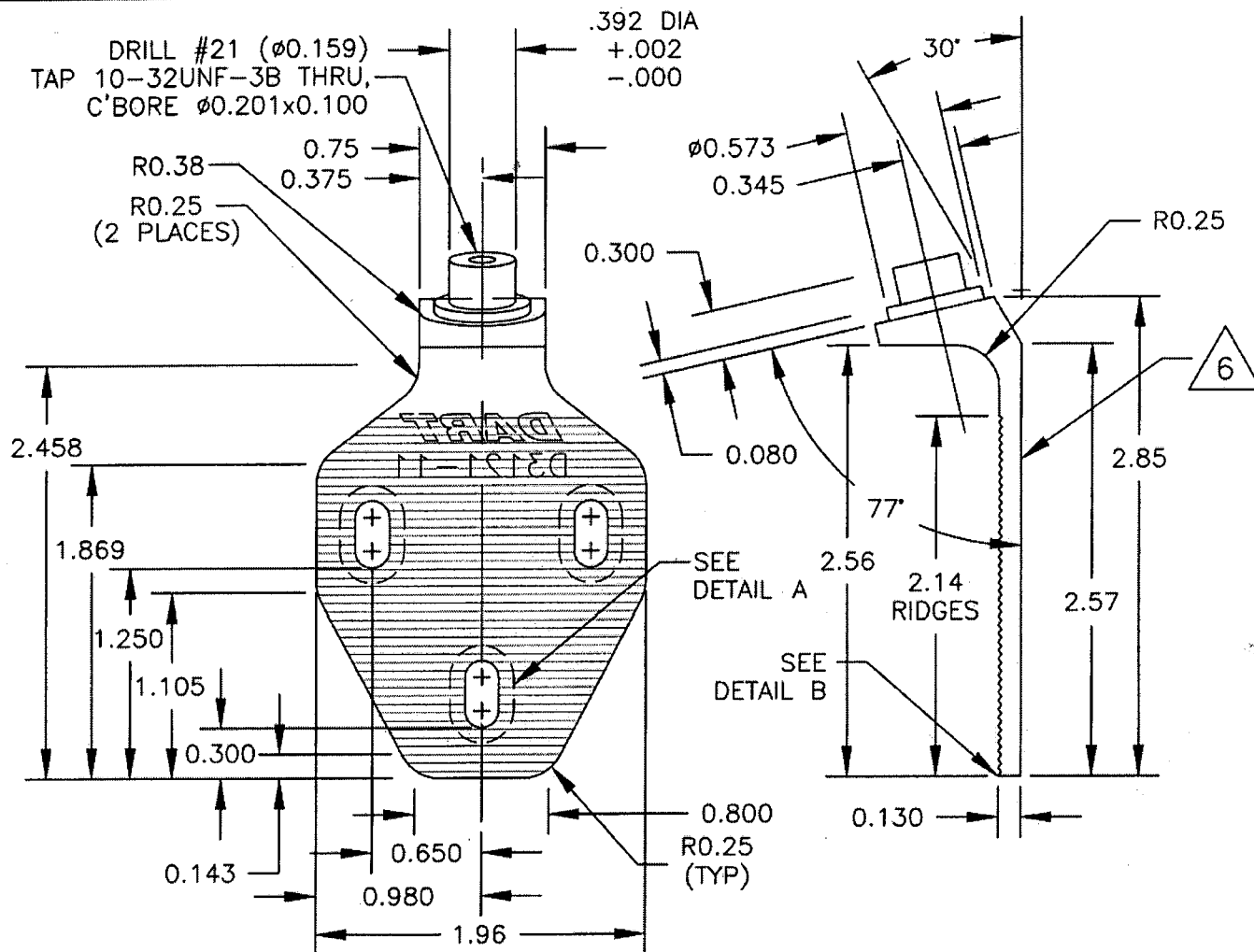
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| DATE 04.02.17 | | TITLE BRACKET ASSEMBLY | SCALE 1:1 |

**D3121-11 BRACKET**

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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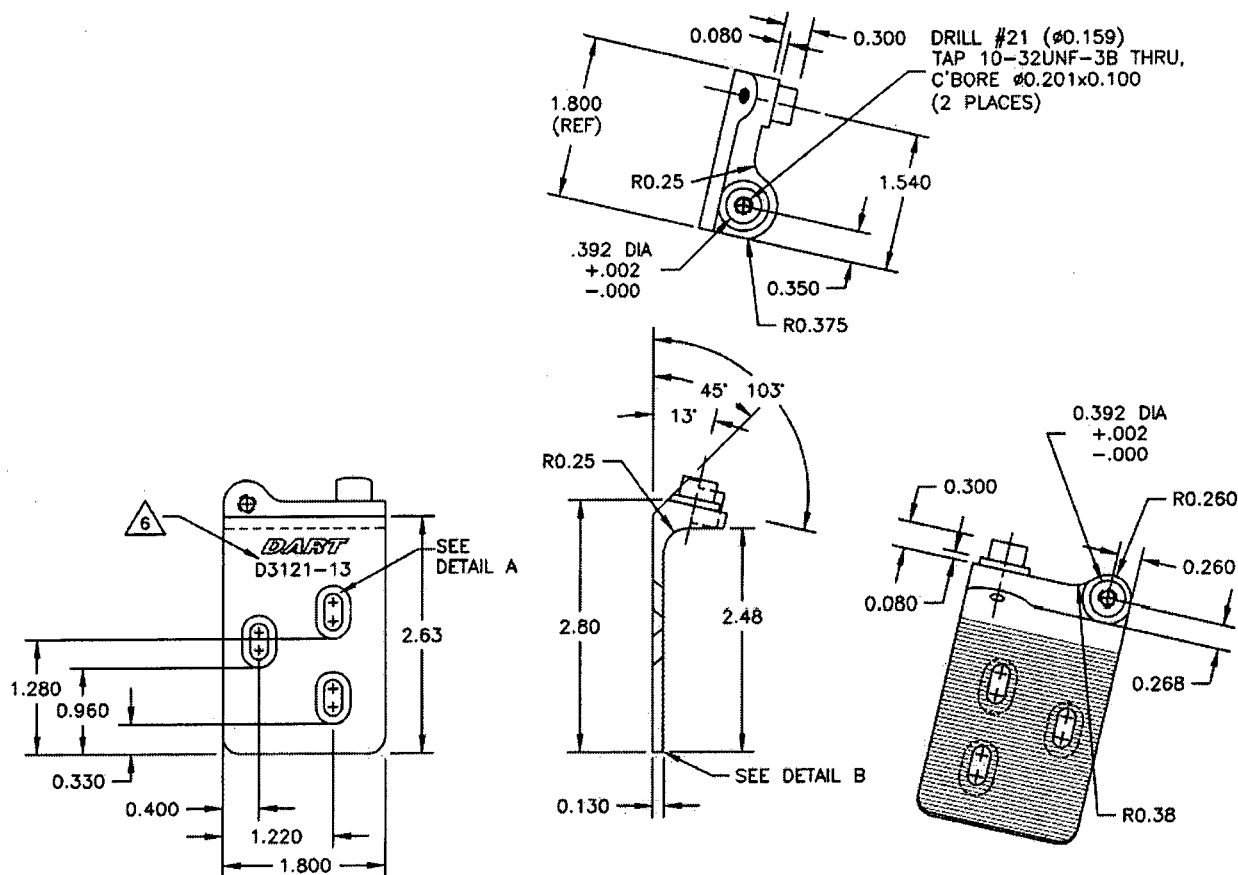
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| DATE 04.02.18 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |



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D3121-13 BRACKET (SHOWN)
D3121-14 BRACKET (OPPOSITE)

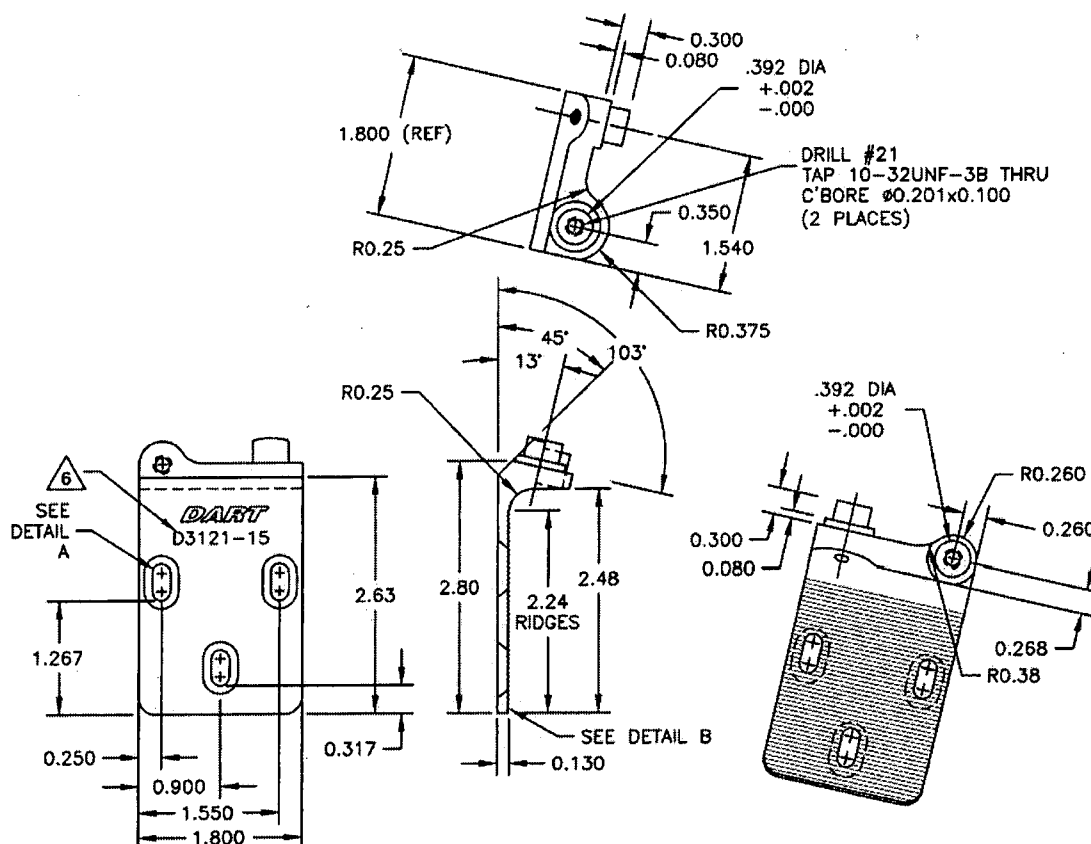
- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N & LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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| DATE 04.02.18 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |



D3121-15 BRACKET (SHOWN)

D3121-16 BRACKET (OPPOSITE)

- 1) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) ENGRAVE DART P/N AND LOGO AS SHOWN
- 6) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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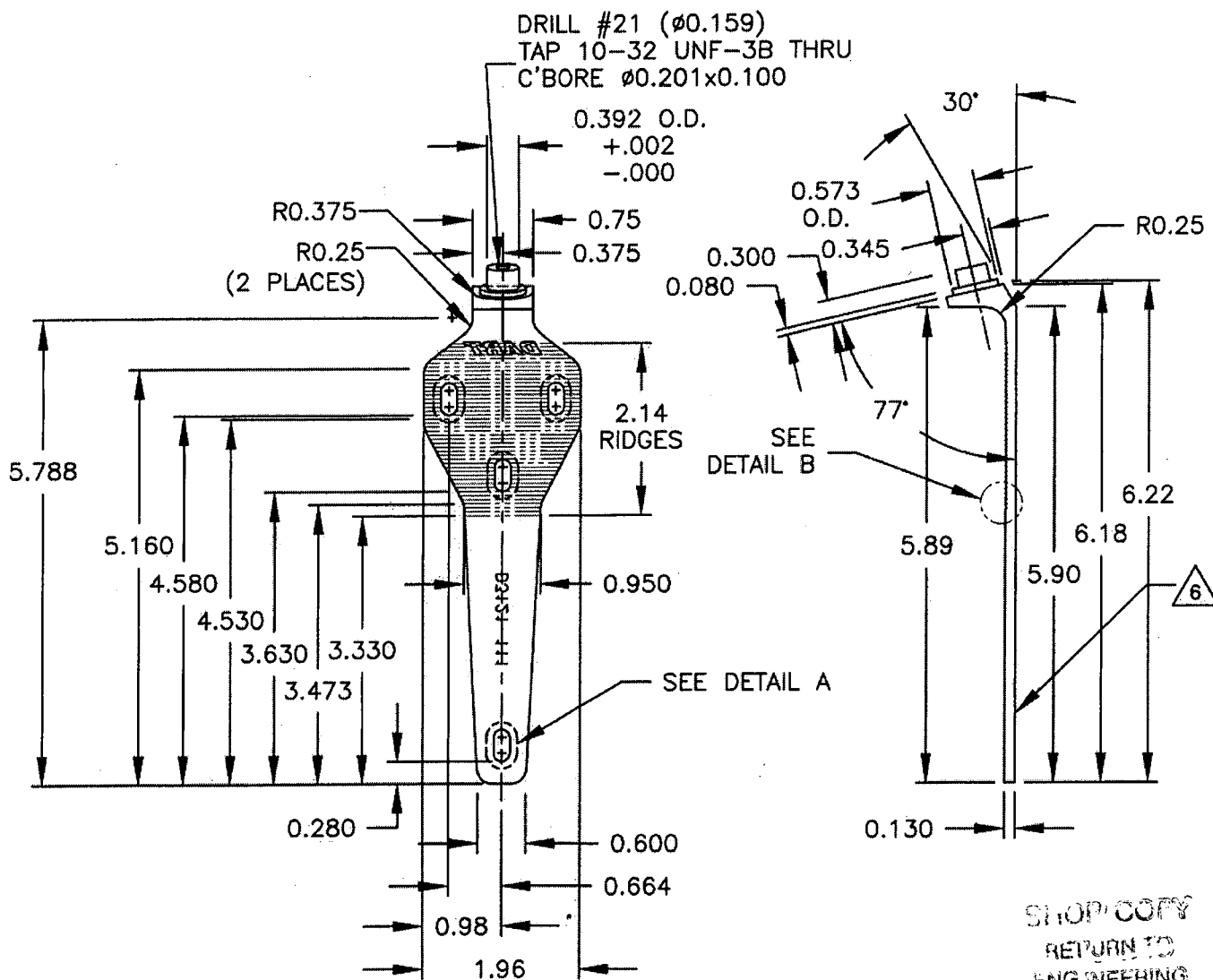
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| DATE 04.02.18 | | TITLE BRACKET ASSEMBLY | SCALE 1:2 |



D3121-111 BRACKET

- 1) REPLACES PREMIER P/N B32-23001-11
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643 (REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE = 150 ksi
MIN YIELD TENSILE = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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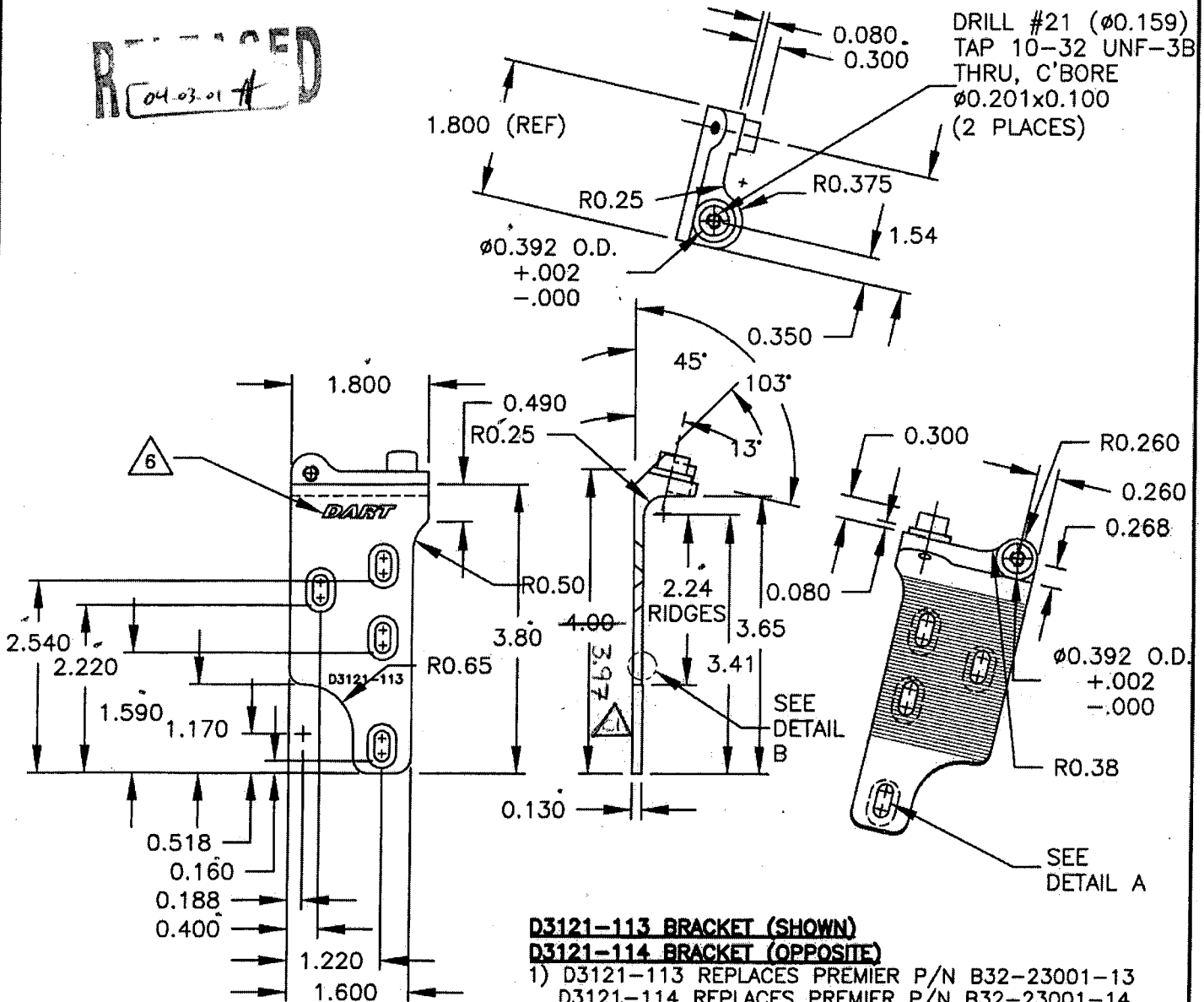
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| | | | |
|----------------------------|-----------------------------|--|-------------------------|
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| CHECKED <i>[Signature]</i> | APPROVED <i>[Signature]</i> | DRAWING NO. D3121 | REV. C SHEET 8 OF 10 |
| DATE 04.02.18 | TITLE BRACKET ASSEMBLY | | SCALE 1:2 |

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04.03.01 *[Signature]*

**D3121-113 BRACKET (SHOWN)****D3121-114 BRACKET (OPPOSITE)**

- 1) D3121-113 REPLACES PREMIER P/N B32-23001-13
D3121-114 REPLACES PREMIER P/N B32-23001-14

- 2) MATERIAL: 17-4 SS PER AMS 5604/5643

(REF DART SPEC. M17-4-B)

MIN ULTIMATE TENSILE STRENGTH = 150 ksi

MIN YIELD TENSILE STRENGTH = 100 ksi

- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 4) ALL DIMENSIONS ARE IN INCHES

- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN

- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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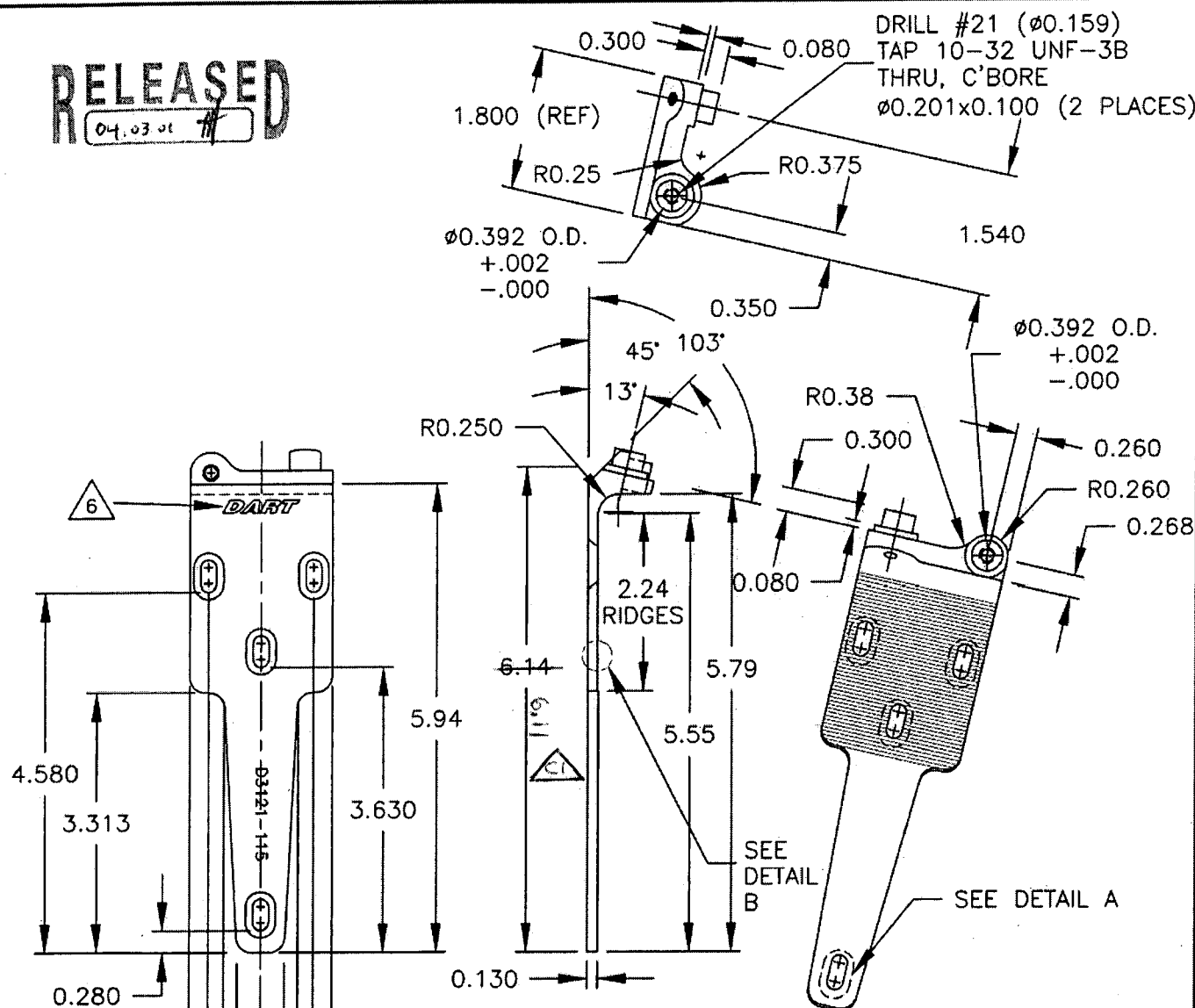
WORK ORDER

NO. 25551B



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| CHECKED [Signature] | APPROVED [Signature] | DRAWING NO. D3121 | REV. C SHEET 9 OF 10 |
| DATE 04.02.18 | TITLE BRACKET ASSEMBLY | | SCALE 1:2 |

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D3121-115 BRACKET (SHOWN)

D3121-116 BRACKET (OPPOSITE)

- 1) D3121-115 REPLACES PREMIER P/N B32-23001-15
D3121-116 REPLACES PREMIER P/N B32-23001-16
- 2) MATERIAL: 17-4 SS PER AMS 5604/5643
(REF DART SPEC. M17-4-B)
MIN ULTIMATE TENSILE STRENGTH = 150 ksi
MIN YIELD TENSILE STRENGTH = 100 ksi
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO IN AREAS SHOWN
- 7) HOLE IN SPIGOT TO BE CONCENTRIC WITHIN 0.005

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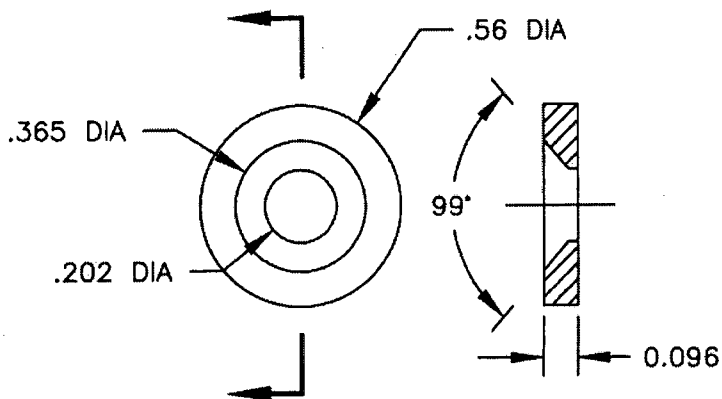
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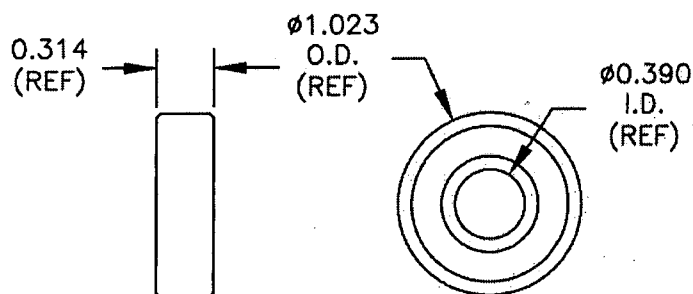


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|------------------|----------------|---|--------------------------|
| DESIGN # | DRAWN BY CP | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED # | APPROVED # | DRAWING NO. D3121 | REV. C SHEET 10 OF 10 |
| DATE 04.02.17 | | TITLE BRACKET ASSEMBLY | SCALE 1:1 |



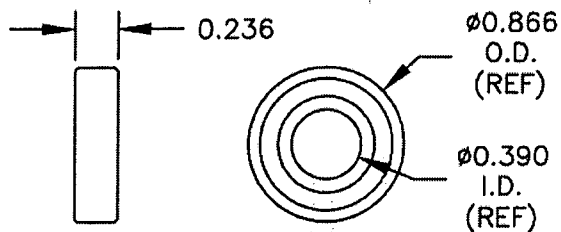
D3121-17 WASHER (SCALE 2:1)

- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



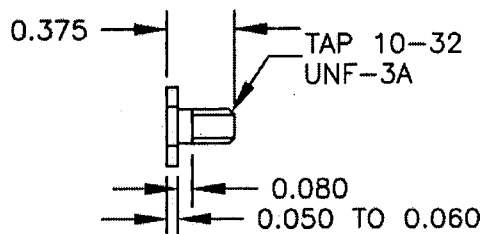
D3121-19 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES



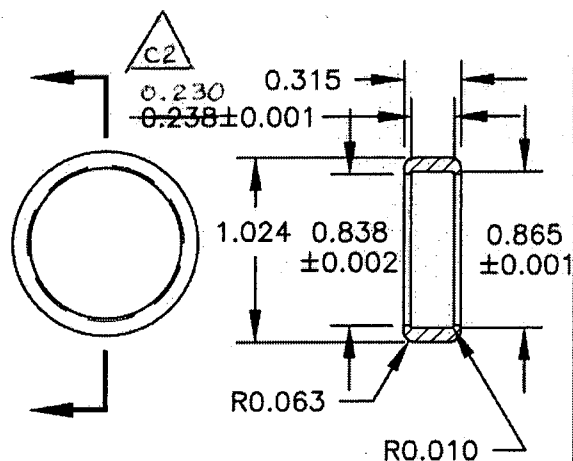
D3121-23 BEARING (SCALE 1:1)

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES



D3121-21 BOLT (SCALE 1:1)

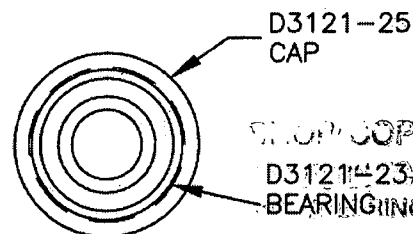
- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015



D3121-25 CAP (SCALE 1:1)

- 1) MATERIAL: DELRIN ROD, 1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

RELEASED
04.03.01



D3121-241 BEARING ASSEMBLY (SCALE 1:1)